

Work Order ID 61886

Wednesday, September 08, 2010 3:52:18 PM

BLUE



Page 1

Item ID: D2724-042

Accept



Setup Start



Revision ID:

Stop



Item Name: 206L Step Assembly

Start Date: 9/8/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/24/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date:

10-9-8

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-2 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

10.09.20

2

φ

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898
followed by Jig
A/R AL ROD Batch: M112860
M114877
Grind end cap welds flush

10.09.20

2

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

=> M

10/09/20

2 0

QC

Memo

0.00

Quality Control

160

Large Fab

0.00

10.09.21

2 0

Large Fab

Memo

0.00

Large Fab

Inspect for foreign object per QSI 024

Weld Remainig end cap as per Dwg D2724
A/R AL ROD Batch: M112860

Grind end plate flush.

170

QC9- Inspect visual per QSI004- Fusion Welds

0.00

10.09.21

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Item Name:	206L Step Assembly					
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Required Date:	9/24/2010	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8, 10/09/21		72 R4			
190  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		⇒ M 10/09/24		2R4			
205  SprayPaint Spray Painting	Spray Painting per QSI005 4.2 Memo PRIME : B 114424 PAINT DELFLEET BLUE : B 115509 CLEAR DELFLEET : B 115506	0.00 0.00							10 09 24 (2)

Dart Aerospace Ltd

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Abstract

Page 5

Accept

Setup Start

[REDACTED]

Stop

Abstract

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Cust Item ID:

Customer:

Reference:

Run Start

(b) (5) DPP, (b) (7)(C), (b) (7)(D)

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

**Insp.
Stamp**



0,00

Quality Control

Wing Walk as per dwg QSI005 4.4 Batch

ML150285 JN 10/09/28

Abstract

HandFinish

Memo

0.00

Hand Finishing

0.00

OC

Memo

0.00

Quality Control

BT 10.09.27 (x2)

2 0

② \varnothing _____

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D2724-042

Accept

Setup Start

Revision ID:

Stop

Item Name: 206L Step Assembly

Start Date: 9/8/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 9/24/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00

PP 61056

10/9/28 SP 28



Packaging

Memo

0.00

Packaging

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/28
MK
10-9-28

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Page 1

Figure 1

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.


3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.



5. The final step is to evaluate the results of the project. This involves assessing the effectiveness of the plan and identifying any areas for improvement or further action.

Required Date: 9/24/2010



Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2734  Step End Plate		Manufactured	No			110	Each	79.0000	1	2		10.09.17	



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	79	
60216	19	
61209	60	

D3458-i	Manufactured	No	110	Each	33.0000	2	4	<i>210.09.17</i>
								
Step Mounting Plate								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	33	
51239	3	
53408	30	

D3458-3	Manufactured	No	110	Each	16.0000	2	4	<i>11.09.17</i>
								
Step Mounting Plate								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	16	
53409	16	

D2734	Manufactured	No	160	Each	79.0000	1	2	<i>10.09.21</i>
								
Step End Plate								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	79	
60216	19	
61209	60	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 61886



Parent Item: D2724-042



Parent Item Name: 206L Step Assembly

Start Date: 9/8/2010

Required Date: 9/24/2010

Start Qty: 2.00

Required Qty: 2.00

D2622-120C

Manufactured

No

100

Each

51.4200

1

2



Step Extrusion



210-09-17

Location

Loc Qty

Loc Code

WA

51.42

55214

3.42

58544

48

2

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Shop Packet Print

Page 2

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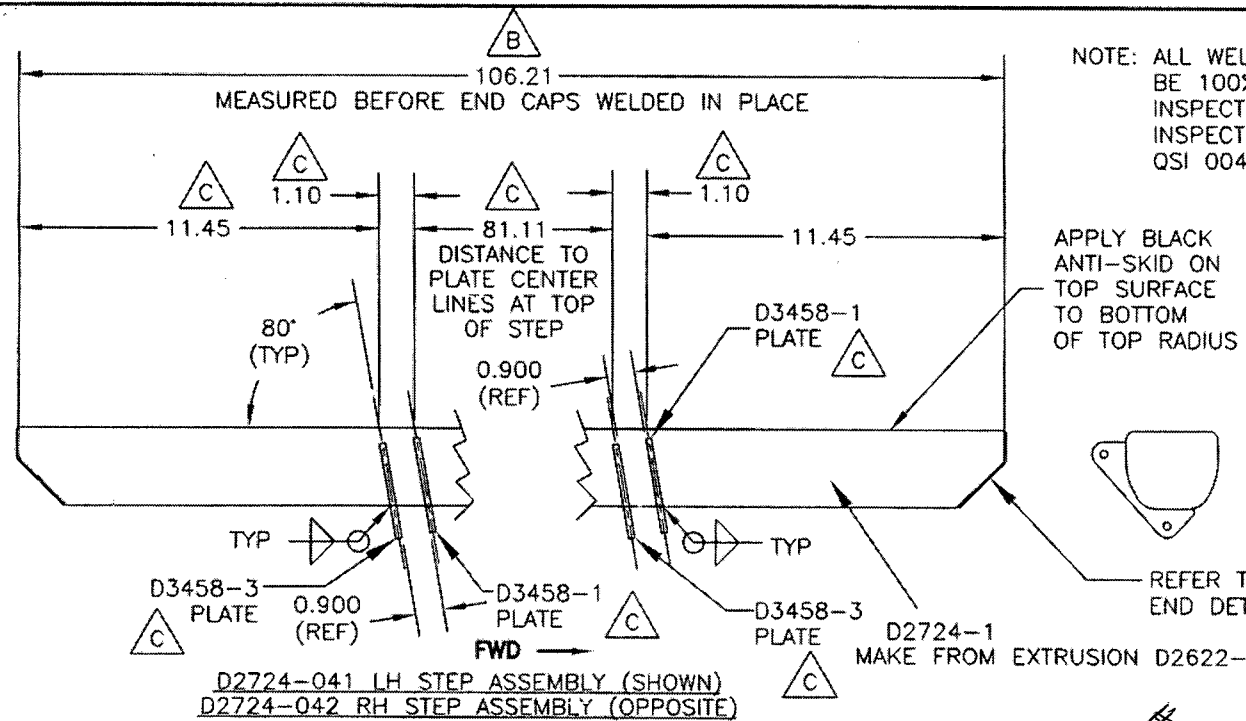
NOTE: Date & initial all entries

DART

RELEASED
05.11.14

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.09.19	TITLE	206L/407 STEP ASSEMBLY	REV: C
	A		97.12.04	NEW ISSUE
	B		98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
	C		05.09.19	RE-DESIGN; ADD D3458-1/-3
		SCALE	NTS	

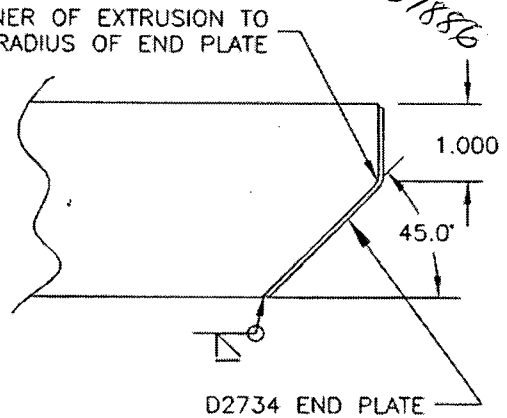
NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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